

Work Order ID 132722

Thursday, May 07, 2015 2:57:01 PM

132722

Page 1

Item ID: D6101-007 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Billet
 Start Date: 5/7/2015 Start Qty: 15.00 ²⁰
 Required Date: 5/7/2015 Req'd Qty: 15.00 ***15***
 Reference: ***15***
 Cust Item ID:
 Customer:

Approvals: Process Plan: CZ Date: MAR 08 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6101	Rev B								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 28432
 a) Description: Alluminum billet
 b) 7.750" x 8.250" x 2.50" thick
 c) Tolerance on all dimensions are +0.030"/-0.000"
 d) Grain direction along 7.750" length
 e) Material: 7075-T7351 (QQ-A-250/12)
 f) Material certification required

CZ MAR 11 2015 20

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure material certification is attached

20x SP15-05-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Work Order ID 132722

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Page 2

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Item ID: D6101-007 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle Billet
 Start Date: 5/7/2015 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				20	0		DAS 14 9-89 15/05/29
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6101								
130	Identify as per dwg & Stock Location: MAT 41	0.00				20	0		DAS 44 9-89 15/05/29
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT044								
140	QC21- Final Inspection - Work Order Release	0.00							15/6/29
140									
QC	Memo	0.00							
Quality Control									

AS-6-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Thursday, May 07, 2015 2:57:00 PM

132722

D6101-007

Required Date: 5/7/2015

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007P

7075-T7351 8.25X7.75X2.5

15-2017
SP 15-05-26

DQA: _____ Date: _____



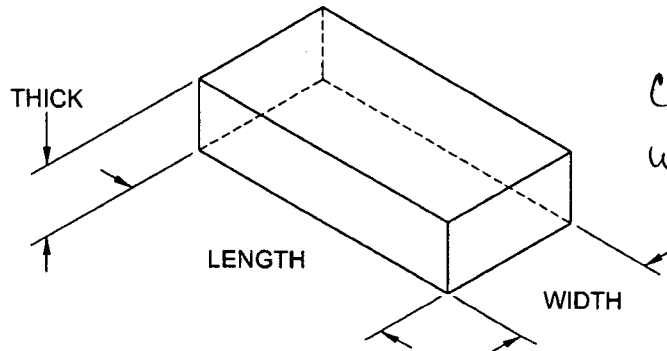
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OTHER : ☐																									

SPECIFICATION CONTROL DRAWING



CY MAR 08 2015
W/O: 132722

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28432

Purchase Order Date 5/11/2015

PO Print Date 5/11/2015

Page Number 2 of 3

Order From :

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

VU-MET002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Total: \$1,183.50

3 D6101-007P 7075-T7351 5/20/2015
8.25X7.75X2.5
Yes
5/20/2015

20.00

Each

\$61.10

\$1,222.00

AS PER DWG D6101 REV. B

B133722

MATERIAL: 7075-T7351 (QQ-A-250/12)

SIZE: 7.750" X 8.250" X 2.50" THICK

GRAIN DIRECTION ALONG: 7.750" LENGTH

TOLERANCE AS PER QUOTE +.030"/-.000"

Line Total: \$1,222.00

4 D6101-013P Saddle Billet 5/20/2015
Yes
5/20/2015

10.00

Each

\$88.80

\$888.00

AS PER DWG D6101 REV. B

B132502

MATERIAL: 7075-T7351 (QQ-A-250/12)

SIZE: 10.100" X 8.250" X 2.50" THICK

GRAIN DIRECTION ALONG: 10.100" LENGTH

TOLERANCE AS PER QUOTE +.030"/-.000"

Line Total: \$888.00

Note:

5/11/2015

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:2613391

Ship From: A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
25-MAY-2015	ORIGIN	Prepaid		MANITOULIN		2613391-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No	Line No	Item No	Description				
3860461	1	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) X 7.75 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12				
Purchase Order No		Part Number		Ordered Qty		Invoice Qty	
28432		YOUR ITEM NUMBER: D6101-007		20.00 PCS		20.00 PCS	
Details			SHIP TO CASTLE, MONTREAL (POINTE-CLAIRE) CUSTOMS BROKER: GEORGE H. YOUNG END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS				
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
120055573				20			330.6337

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.
Date Printed: 25-MAY-2015 10:26:20 AM



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

Reviewed by Authorized Castle Metals Representative:

Date:

Name:



25 MAI 2015

[Handwritten signature]

SHIP TO: A M CASTLE & CO 3050 SOUTH HYDRAULIC WICHITA, KS 67216
SOLD TO: AM CASTLE & CO- SOLD TO 1420 KENSINGTON RD SUITE 220 OAK BROOK, IL 60523

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4304789

CUSTOMER PO NUMBER: 228162	WORK PACKAGE:	CUSTOMER PART NUMBER: 752247	SHIP RUN/LOAD: 102695/11	GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1154968	LINE ITEM: 1	SHIP DATE: 26-JUL-2013	ALLOY: 7075	CLAD: BARE	TEMPER: T735T	PRODUCT DESCRIPTION: Kaiser Select® Plate
WEIGHT SHIPPED: 3584 LB	QUANTITY: 2 PCS EST.	TRUCK B/L #: 2043309	GUAGE: 2.5000 IN (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)	LENGTH: 144.500 IN (3670.3 MM)	

MHU 1699372: LOT 646617A1; 2 pieces;

Certified Specifications

AMS 4078/RevJ
ASTM B 209/Rev10
BSS 7055/RevA
DPS 4.713/RevAK
GSS16100/RevG/Amd1

AMS-QQ-A-250/12
ASTM B 594/Rev09
CMMP 025/RevU
EAC MS1011/RevE
MMS 159/RevT

AMS-STD-2154/RevA
BAC 5439/RevH
CSTI 006/RevD
GAMPS 9101/RevB
PS 21211/RevL

Test Code: 4297

Test Results

DAS
14
9-89

Lot: 646617A1 Cast 545

Drop 17

Ingot 1

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper T735	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 68.9 : 69.6 (475 : 480)	Yield KSI (MPA) 57.8 : 58.3 (399 : 402)	Elongation % 11.2 : 11.6
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(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	40.8 Min	41.2 Max
(MS/M) :	23.7 Min	23.9 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.09	0.21	1.4	0.04	2.4	0.20	5.7	0.03	0.01	0.02	TOT 0.05



KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4304789

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

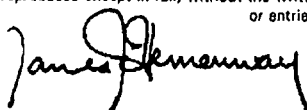
Aluminum Remainder

TEST NOTES

Metal represented by this test report was 100% immersion ultrasonically tested from one side with 3mm dead zones top and bottom and meets the Class A and Class B requirements of all specifications referenced on this test report. No surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2000 certified.



JAMES HEMENWAY, LABORATORIES SUPERVISOR

